

X-TRONIC USA



X-Tronic™ Model #6040-XTS Instructions

PLEASE READ THIS MANUAL BEFORE USING YOUR NEW X-TRONIC Model #6040-XTS SOLDERING STATION

This manual is provided to make a safe and effective use of the X-Tronic 6040-XTS soldering station and to maintain this instrument in proper working condition. Be sure to keep this booklet in a handy place near the unit for future reference.

SPECIFICATIONS

Model	#6040-XTS
Power Consumption	700 Watts
Dimensions	4 x 5.5 x 6 in
Weight	3.8 lbs
Working Environment	32°F ~ 122°F / 0°C ~ 50°C
Storing Environment	-68°F ~ 176°F / -20°C ~ 80°C
Hot Air Rework	
Airflow Type	Brushless Ball
Airflow	≤ 120 L/min
Temperature Range	212°F ~ 896°F / 100°C ~ 480°C
Temperature Stability	± 1°C
Display Type	LCD
Cable Length (Material)	≥ 39.4 in / 100 cm (Silicone)
Soldering Iron	
Temperature Range	392°F ~ 896°F / 200°C ~ 480°C
Temperature Stability	± 1°C
Output Voltage	24 V
Tip Impedance	< 2Ω
Display Type	LCD
Cable Length (Material)	≥ 39.4 in / 100 cm (Silicone)

INITIAL SET-UP

1. Plug the 3-Prong AC cord into a 110/120V grounded outlet to prevent electric shock or injury.
2. Turn the power on by pushing the power switch on the back of the unit. Both LED displays will show "---" and will be blinking.

HOT AIR GUN

1. **IMPORTANT:** Insert the hot air gun into holder on the side of the unit. If the hot air gun is not mounted in the holder, it cannot be programmed.
2. Turn on the Hot Air Power Switch on the lower left hand side of the unit - the LED display will show the last used hot air temperature for about 1 second and then change to "- - -". This means the hot air gun is ready to be programmed.
3. Push the ENTER button - the first digit (of 3) will start blinking. Push the UP or DOWN button to select the first digit of the temperature and then push ENTER. The second digit (of 3) will start blinking. Push the UP or DOWN button to select the second digit of the temperature and then push ENTER. The third digit (of 3) will start blinking. Push the UP or DOWN button to select the third digit of the temperature and then push ENTER. Once the ENTER button has been pushed for the forth time, the LED Display will show "- - -". The hot air gun is now in the Standby State and set at the programmed temperature.
4. When the hot air gun is removed from the holder it will ramp up to the programmed temperature in about 5 to 8 seconds.
5. When the hot air gun is not in use- set it back in the holster, it will keep running until the temperature gets back down to 100°C and then shut off.
6. When the hot air gun is removed again from the holder it will ramp up to the programmed temperature in about 5 to 8 seconds. This is a safety feature built into the unit.
7. To turn the hot air gun completely off - turn off the power switch.

IMPORTANT: Do not unplug the unit or shut off the Main Power Switch on the back of the unit until you have placed the hot air gun in the holder and it has cooled down and shut itself off automatically.

Note: The °C/°F toggle switch can be flipped to switch from Celcius to Fahrenheit and back at any time.

SOLDERING IRON

1. Plug the Soldering Iron into the front power receptacle of the unit and tighten the ring nut.

2. Turn on the soldering iron power switch - the LED display will light up. Push the ENTER button 4 times -the first digit (of 3) for the soldering iron will start blinking. Push the UP or DOWN button to select the first digit of the temperature and then push ENTER. The second digit (of 3) will start blinking. Push the UP or DOWN button to select the second digit of the temperature and then push ENTER. The third digit (of 3) will start blinking. Push the UP or DOWN button to select the third digit of the temperature and then push ENTER.
3. To turn the soldering iron completely off - turn off the power switch.

Note: The °C/°F toggle switch can be flipped to switch from Celcius to Fahrenheit and back at any time.

AIR FLOW

1. Take the hot air gun out of the holder - it will start heating and blowing.
2. Adjust the air flow with the Air Flow Control Knob from 1 up to 8.
Important: Do NOT use a temperature higher than 300°C on the hot air gun with the air flow set at less than 5. Doing so WILL damage the hot air gun and decrease the life of the heating element.

MAINTENANCE

Do NOT put excess pressure on the tip. It can damage the element.

TO REPLACE TIP:

1. Turn off the soldering station, unplug the power cord from the power source and allow the soldering iron to cool down to room temperature. **Never attempt to remove the tip while the iron is hot.**
2. Unscrew the larger metal tip retaining screw ring at the bottom of the soldering irons metal shaft. Slide off or remove the soldering tip retaining collar. Now, remove the tip by sliding it forward.
3. Slide a new tip over the exposed ceramic heating element, slide the metal retaining collar over the new soldering tip back onto the soldering iron.
4. Tighten the metal tip retaining screw ring to snug the tip into place. Do not over tighten the tip retaining screw
5. Plug the soldering iron AC cord into a grounded outlet to resume soldering.

TO REPLACE THE HEATING ELEMENT:

1. Allow the soldering iron to cool down to room temperature. Never attempt to remove the tip while the iron is hot.

2. Remove the soldering tip and metal soldering tip retaining collar using the above procedure. Unscrew the Black "Bakelite Polymer" Retaining Cap and slide off this secondary heating element retaining collar.
3. Push the Power Cord through the bottom of the soldering iron while (at the same time) gently pulling the heating element out of the top of the iron.
4. De-solder the 2 Red and 2 Blue wires that have heat shielding on them from the circuit board and pull the heating element away from the mother board. Please take note of the wire colors and location for installation of new heating element.
5. Install new heating element and solder Red & Blue Wires to the new heating element.
6. Pull the cord back gently and align the PC board to the slot so the cord can be pulled back to its original position.
7. Replace Bakelite Polymer Retaining Cap and screw back on and hand tighten.
8. Install the soldering tip, slide the metal soldering tip retaining collar and hand tighten it. Plug the AC cord back into a grounded Outlet.

NOTE: The wires on the heating element can be soldered back onto the board on either solder pad as there is no polarity for the element.

SOLDERING TIPS PREPARATION & CARE

1. Keep the soldering tip properly tinned. Always use solder with sufficient rosin flux or the tip will de-wet. A well tinned tip will be bright all over when hot, with no dull or discolored spots.
2. To tin the iron, do the following:
 - a. Plug in the iron and allow it to reach solder melt temperature.
 - b. Flood the tip with solder and let it stand for one minute.
 - c. Apply more solder to the tip, allow it to idle for one or two more minutes, wipe it lightly on the sponge. Do not remove all of the solder, but use the sponge to remove excess solder and wipe solder onto non-tinned areas.
3. Do not file or attempt to reshape the tip. This will destroy the plating and shorten tip life. Do not use chloride and acid fluxes; they will also shorten tip and heater life.
4. For maximum tip life, always apply solder to the heated connections or joints. Repeated application of solder directly to the tip will shorten the tip life.

WARNING: Do NOT use anti-seize or any other lubricant on the tip retainer or heater of the soldering iron.

X-TRONIC INTERNATIONAL, INC.

3-YEAR WARRANTY

All X-Tronic Products come with 3-Year Guarantee, valid only in the 48 Contiguous United States. If you purchase this product and ship it to a destination outside of the 48 Contiguous United States this warranty becomes null and void. This Guarantee covers the main unit itself. Consumable parts such as soldering tips, heating elements, nozzles, etc. are not covered by this warranty.

The first 30 Days are covered by a Money Back or Replacement Guarantee from the date of the receipt of the product. If your product becomes damaged in shipment or is found to be defective in any way during this period, we will replace or issue a complete refund for your product upon return. We will pay all shipping involved during this first 30-day period.

The remainder of the 3 Years (after the first 30 days) is covered by a FREE REPAIR Guarantee (parts and labor included). If anything becomes defective during this period we will fix the issue and provide a full service inspection to your product, shipping (to & from) will be paid by the buyer. Please email us at Info@XTronicUSA.com to set up a service request.

Returns of New/Unused Products

If you have Buyer's Remorse and decide that you do not want the product, it must be returned NEW & UNUSED in the original box and you will pay the return shipping. PLEASE NOTE: There will be a 10% Restocking Fee and original Shipping Costs (if applicable) will not be refunded. **Used product cannot be returned.**

How To Register Your Warranty

Go to www.XTronicUSA.com. Click on "Register Your Warranty" tab and fill out the form. This is a fully secure website. Your information will never be sold or misused in any way. This registration site is strictly for order verification that will be used to speed up the process should you ever need to use your Warranty for service.

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QUESTIONS, PROBLEMS OR COMPLIMENTS?

***Thank You for purchasing this
X-Tronic International Product!
We are grateful for your business!***

All of our X-Tronic International Products are inspected then sealed with our NEW Product Seal prior to shipment. Our goal is to ensure Quality, Completeness, and Satisfaction for your order.

**For Any Questions, Problems, or
Compliments please call or email us.**



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